

Date: Monday, 23/02/2009 10:14:27 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT TUBE ASSEMBLY
Job Number : 45966	
Estimate Number : 10699	
P.O. Number :	Part Number : D3391025
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3391 REV H
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : H
Previous Run : 41762	Material :
Written By :	Due Date : 10/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.02.23</u>	
Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manuf. Instructions JLM	
est rev D 07.03.20 revF dwg EC est rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD Est Rev:F 07-11-13 ECN 1056 DD verified by: EC Est Rev:G 08-09-10 revH as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D6014-090	Extrusion	B32309

Identify as D3391-3

inc *q.m* 09.02.25 @

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: H & Dwg D3391 Rev: AA

q.m 09.02.26 @

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

q.m 09.02.26 @

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS1-Machine as per Folio FA 599 Rev: H & Dwg D3391 Rev: H

2-Deburr

H.A 09/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45966

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.A 09/03/01

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/03/03

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

M 9-3-3

8.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

MB 09-03-04

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

measure 4.450" in height.

SP 09/03/04 (X1)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

9-3-5

M 9-3-9

Tools: rill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45966

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0903-10 ①

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

① M 9-3-11

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD 9-3-11

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch:

B 41263 ④

M 9-3-11

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398

Batch: M109900

exp. date:

9-9-19

M 9-3-11

cure time 12hrs as per QSI0015

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0903-12 ①

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939 Pressure wash

cmp/Fd

09/03/13

START TIME:

12:45

OVEN TEMPERATURE:

320°

FINISH TIME:

13:15

cmp/Fd

⑪
09/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45966

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-25

(X1)

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number Description Batch

1

D2646

Aft Cap

B41435

HL

20.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD B415352

HL

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearpad B33869

HL

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket B33868

HL

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket B33870

HL

24.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PHENOLIC WASHER

B339275

HL

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

INSERT

batch: M108606

X

HL

09-03-25

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45966

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent per
QSI 017

JS 09-03-25 (X1)

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
INSERT
or equivalent
Per QSI 017 M19393 JS

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
2 AN3C4A Bolt M110985 JS

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt M110916 JS

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Inventory
Pick:
Qty Part Number Description Batch
2 AN960C10L Washer M111193 JS

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
✓ 1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391
✓ A/R Sikaflex-241/-291 M109883
Sikaflex expiry date: 09111

JS 09-03-25 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 45966

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/03/25 (P)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

OFF 46459

9/4/11

SD

(P)

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 (P)

Job Completion



mf
09 04-01.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45960
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G/11	Page 1 of 1

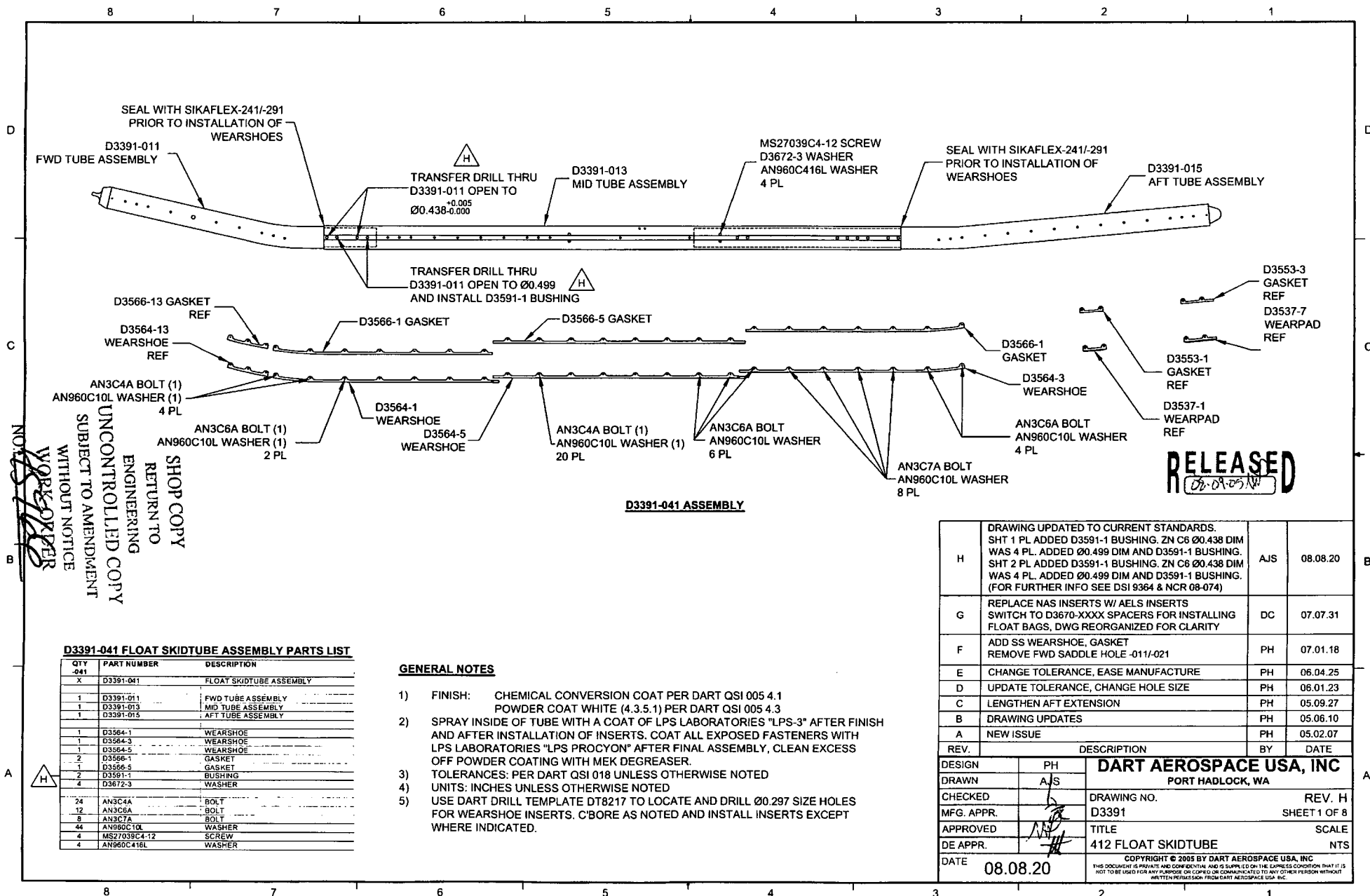
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.930	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.203	✓			
1.526	+0.000/-0.030	1.510	✓			
0.200	+/-0.010	0.200	✓			
7.500	+/-0.010	7.496	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.300	✓			
0.200	+/-0.010	0.200	✓			
3.520	+/-0.010	3.518	✓			
0.687	+0.010/-0.000	0.691	✓			
R0.062	+/-0.010	R 0.063	✓			
Ø0.484	+0.005/-0.001	Ø0.487	✓			

Measured by: a.m. / 09/02/03	Audited by: SS	Prototype Approval:	N/A
Date: 09.02.06	Date: 09/02/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\phi 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

REV.	DESCRIPTION	BY	DATE
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 $\phi 0.438$ DIM WAS 4 PL. ADDED $\phi 0.499$ DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 $\phi 0.438$ DIM WAS 4 PL. ADDED $\phi 0.499$ DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 1 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE	SCALE
DE APPR.			NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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D

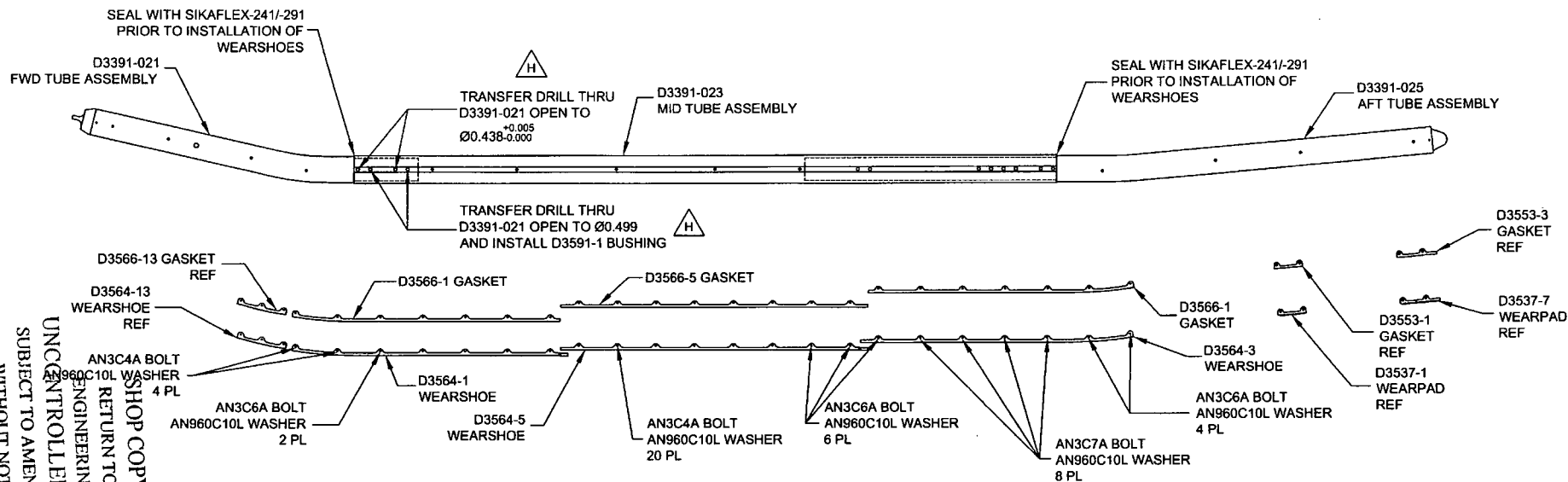
C

D

C

B

A



D3391-043 ASSEMBLY

D3391-043 FLOAT SKID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKID TUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

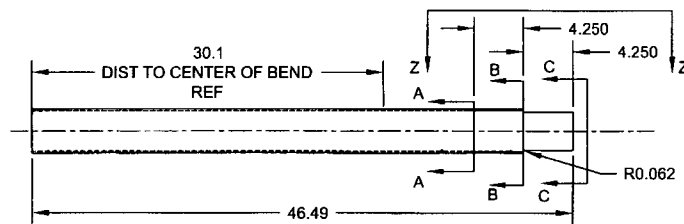
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

RELEASED
08-09-25/18

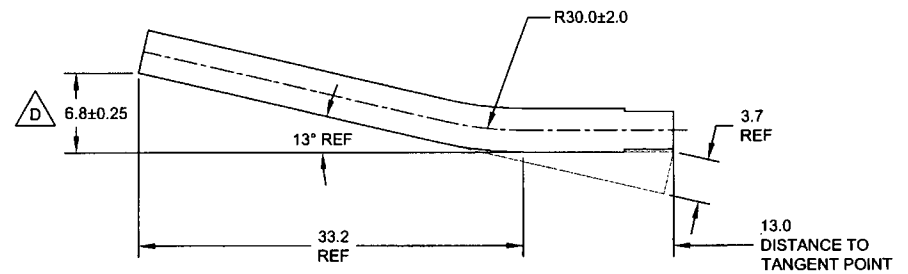
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DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKID TUBE	NTS
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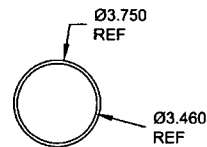
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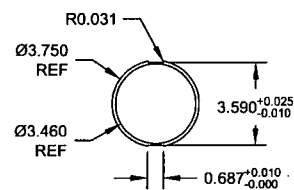
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



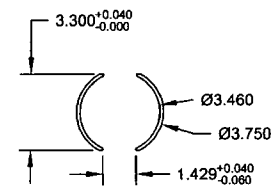
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



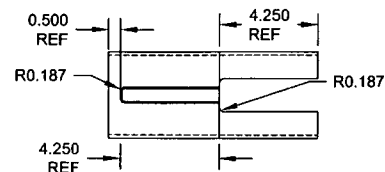
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

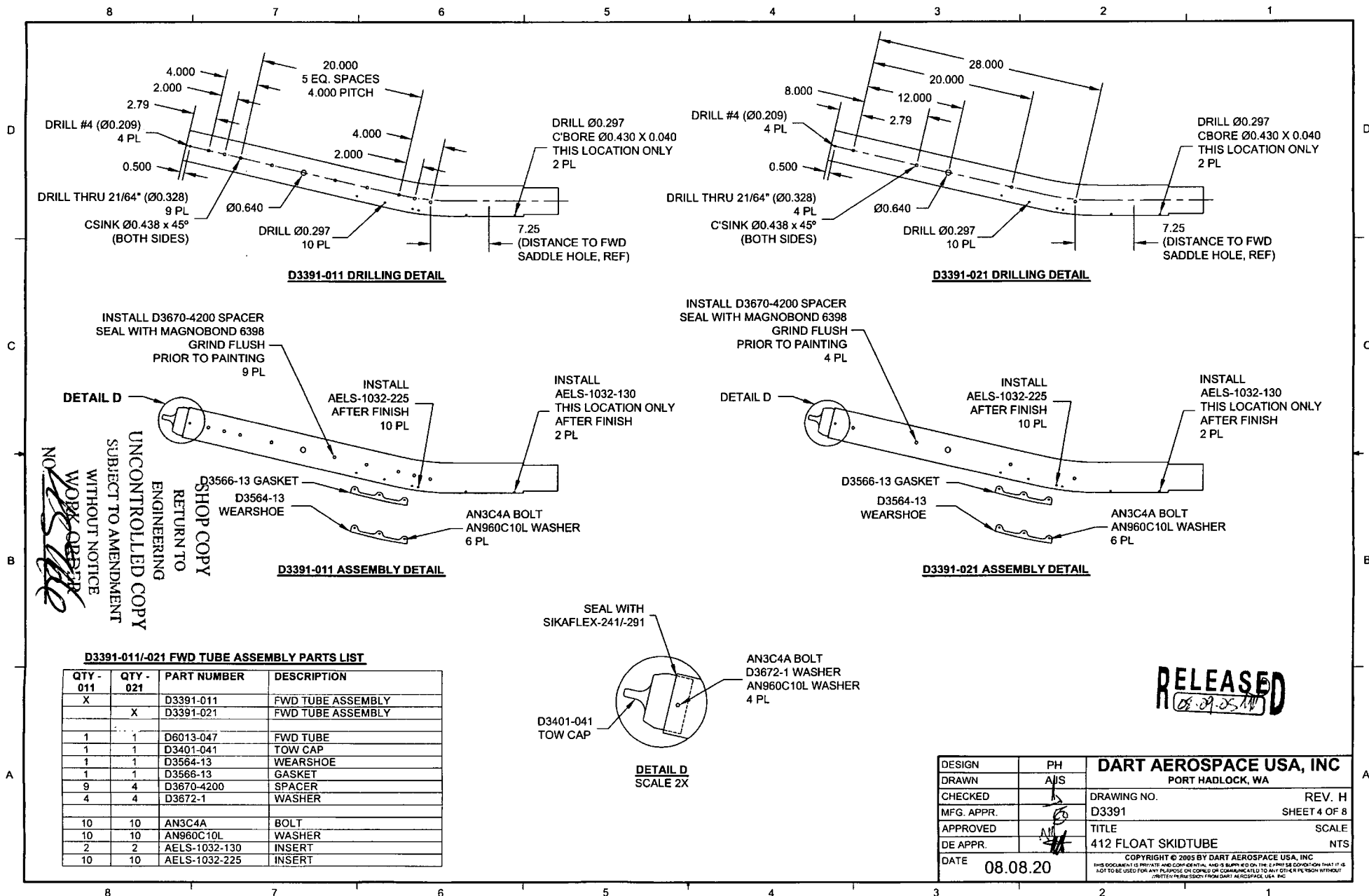


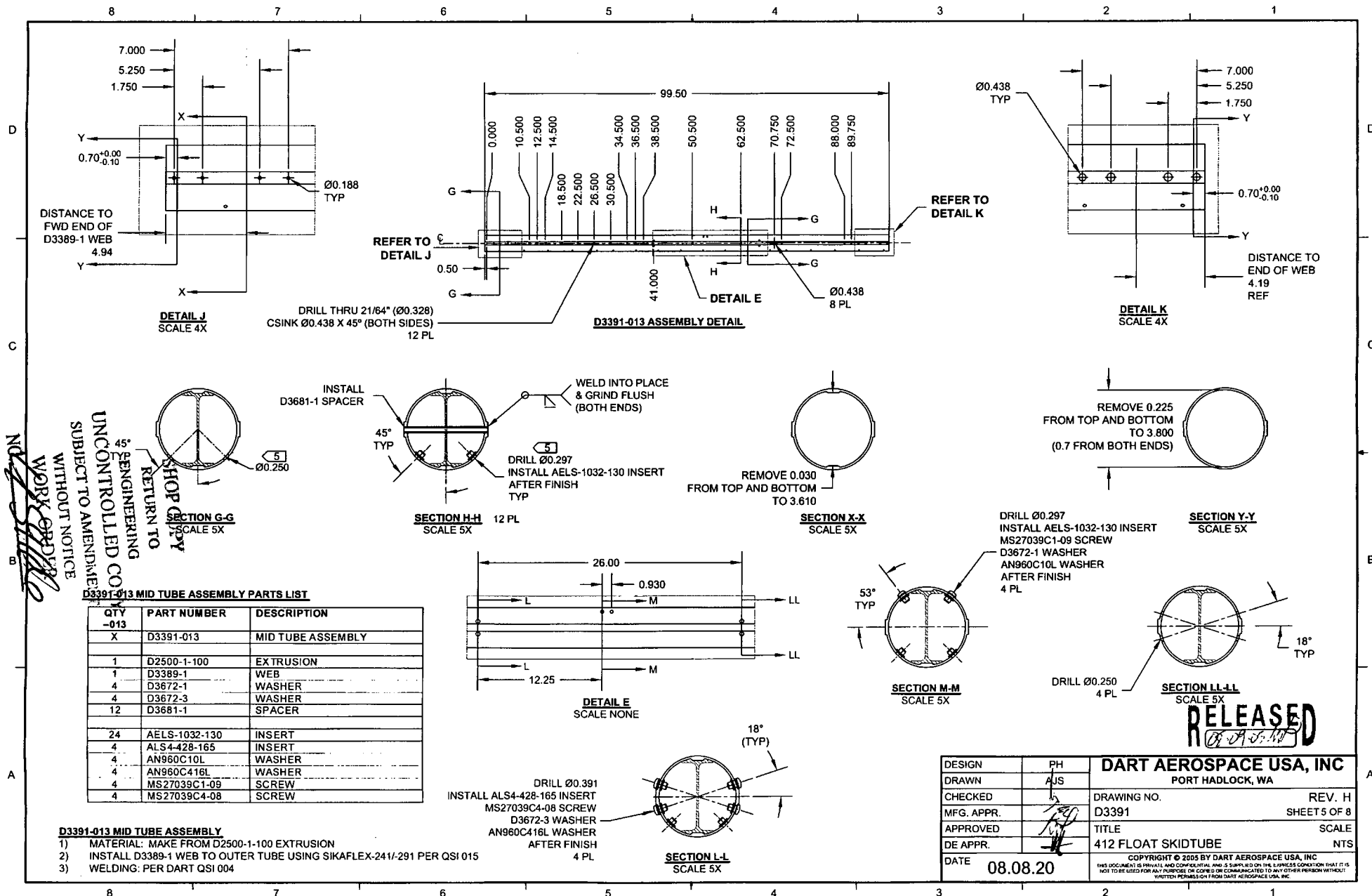
VIEW Z-Z
SCALE 2X

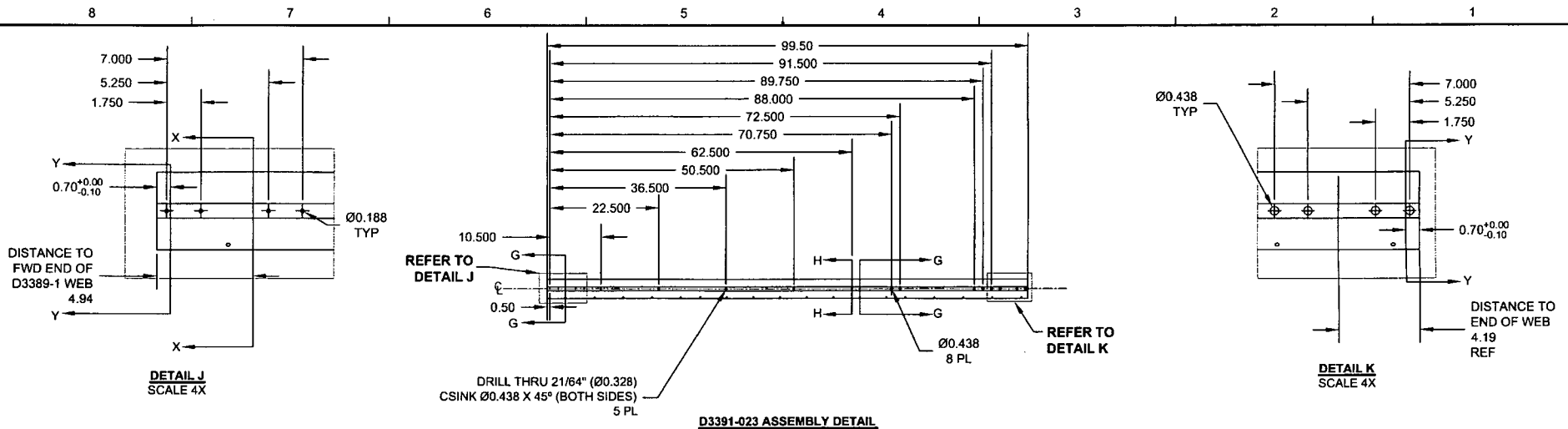
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE	SCALE
DE APPR.			NTS
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DETAIL J
SCALE 4X

DETAIL K
SCALE 4X

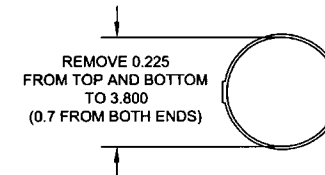
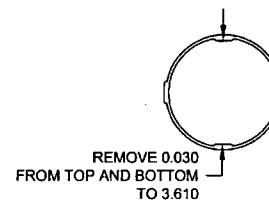
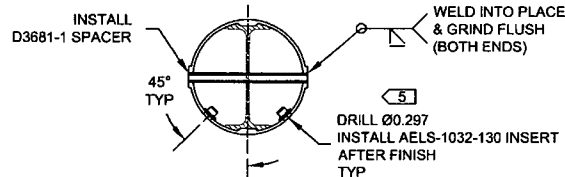
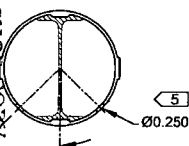
D3391-023 ASSEMBLY DETAIL

SECTION G-G
SCALE 5X

SECTION H-H
SCALE 5X

SECTION X-X
SCALE 5X

SECTION Y-Y
SCALE 5X



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
08-05-17

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	A/S	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. H SHEET 6 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE
DE APPR.		SCALE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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